

Date: Thursday, 11/15/2007 1:27:09 PM
 User: Kim Johnston

①
 Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY ✓
 Job Number : 35779 -2
 Estimate Number : 10911
 P.O. Number : N/A
 This Issue : 11/15/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 32890
 Written By :
 Checked & Approved By : 11/16/07
 Comment : Est A 05.09.01 New issue KJ/JLM

Part Number : D3405041
 Drawing Number : D3405 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 12/2/2007 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



4.851



Comment: Qty.: 0.1617 sf(s)/Unit Total: 3.2340 sf(s)

304/316 .125 Sheet

(M304S11GA)

Batch: 104934 B 07-11-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: A

Prog Rev: A

B 07-11-19



2-Deburr if necessary

B 07-11-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 07-11-19



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Calul's (29) counts

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

→ CPOB/01/04 (29)
 SB 28/01/04



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Drawing Name: LUG ASSEMBLY

Job Number: 35779

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

08/01/14

(X22)

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B35810

A/R

SS Rod

M106115

08/01/14 (3x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

08/01/14 (3x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/14 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/14 (X3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-01-15 (X3)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/15 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51474

08/01/15 (X3)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 35779

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

③

208/01/16

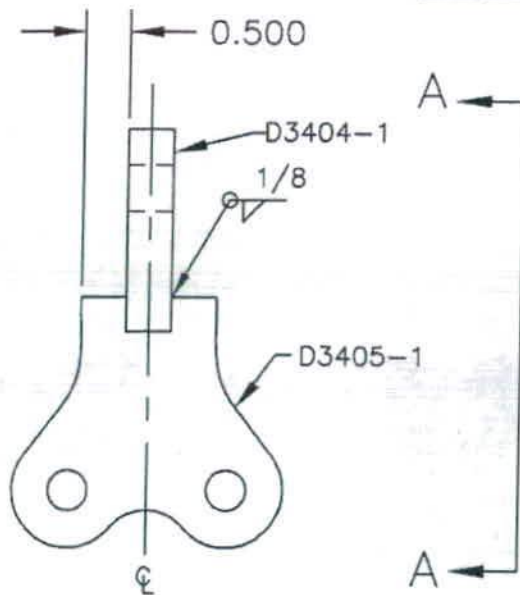
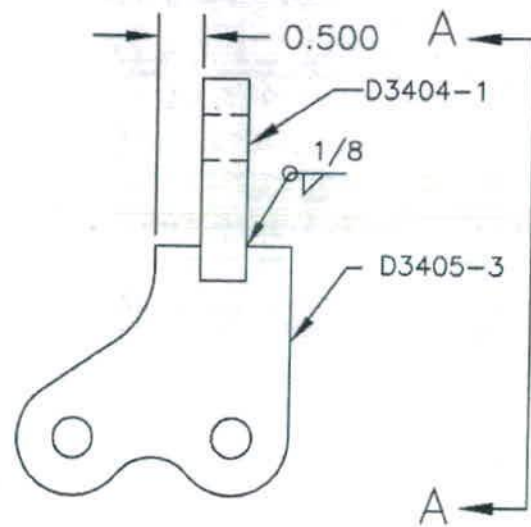
Job Completion



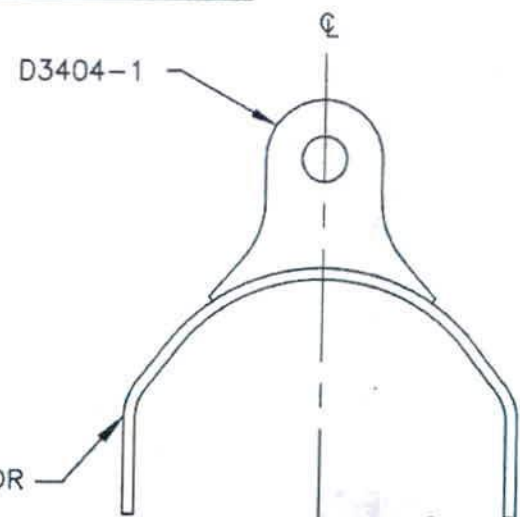
u 08.01.15

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]***D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

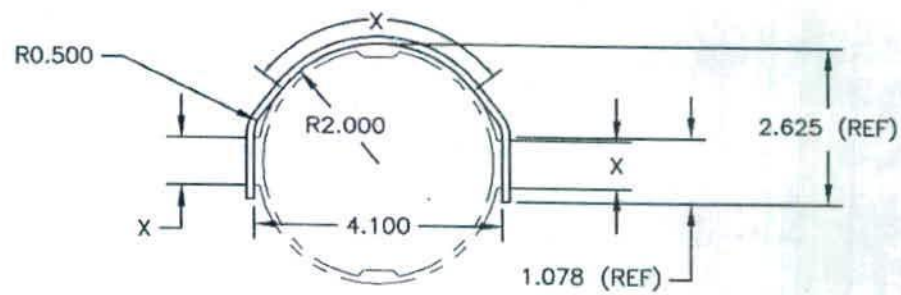
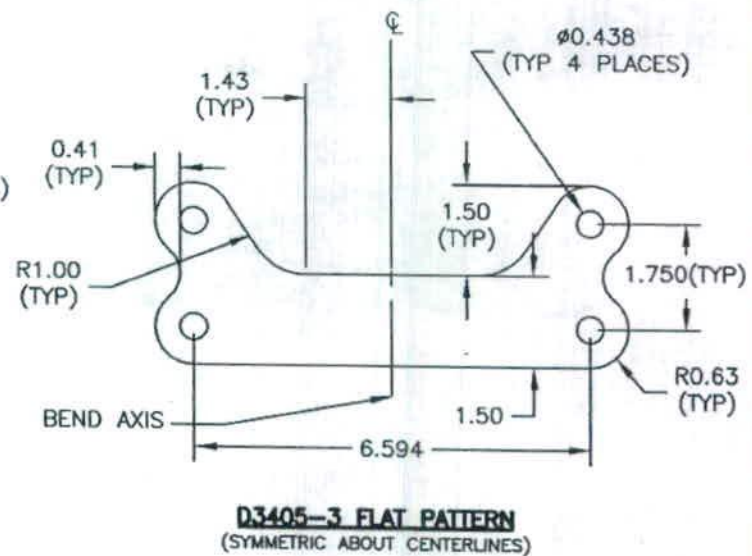
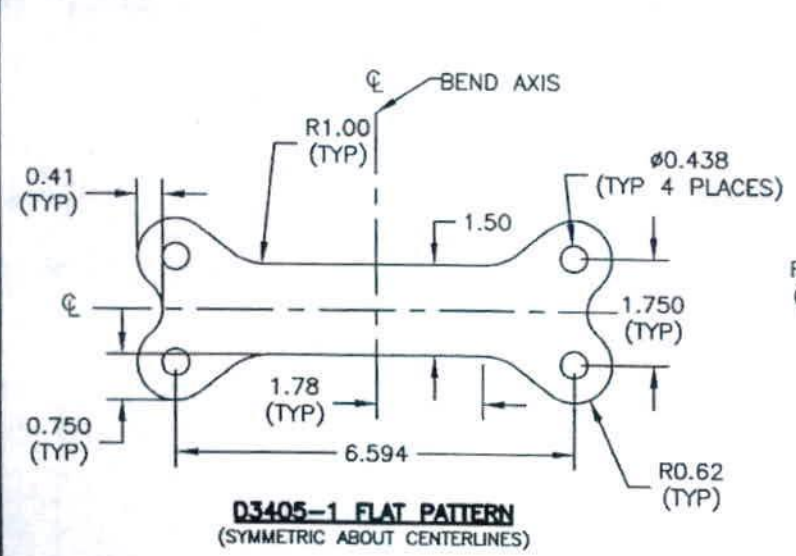
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DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	CHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 CHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.08.09
NO. 35714
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